

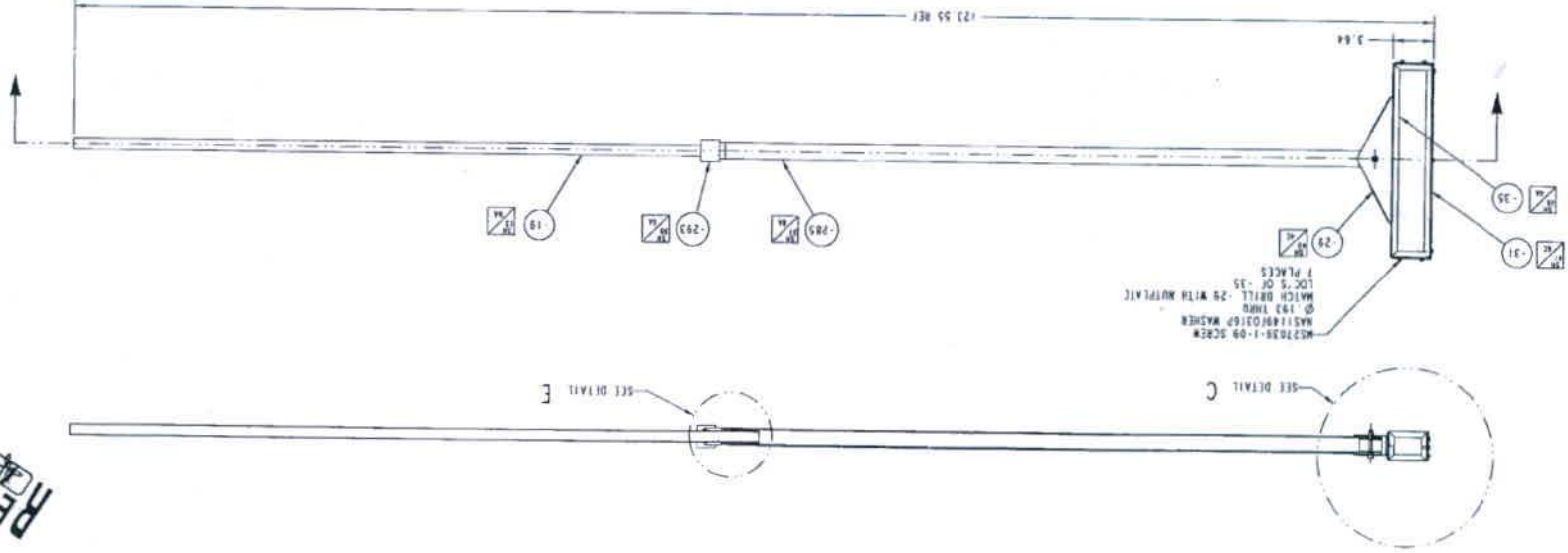
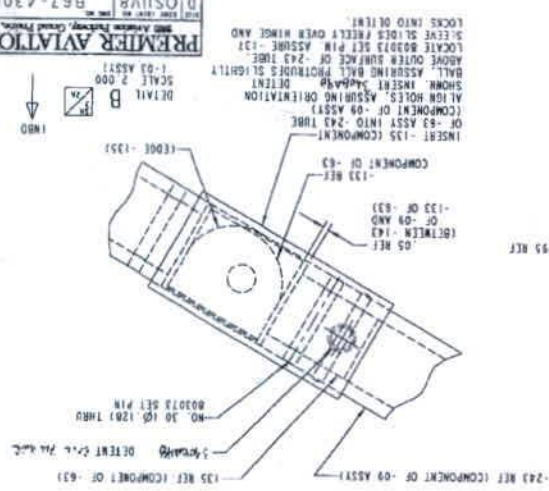
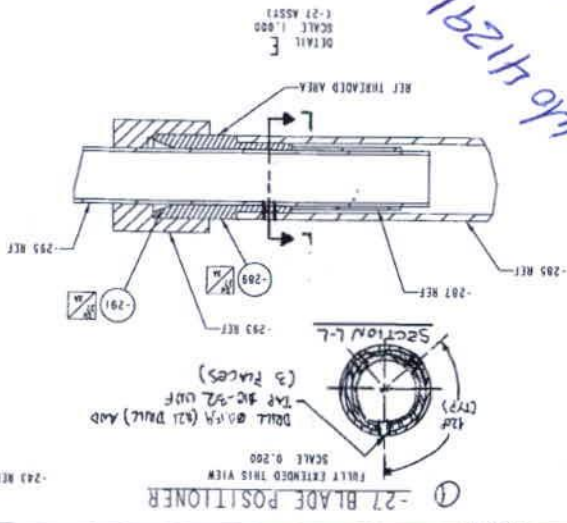
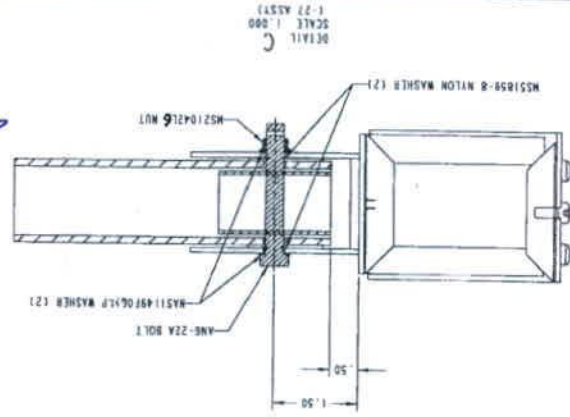
RECEIVED 1974

ORIGINAL



REFERENCE ONLY

162115 07m



PREMIER AVIATION, INC.
3800 American Parkway, Grand Prairie, Texas 75042

DISCLOSURE	DATE: 10/10/2001	TIME: 10:00 AM
667-43001	INSTR: 4	45

ORIGINAL

RELEASED
JUL 26 1962

HEREIN IS CONTAINED

[illegible]

REVIEWS			
REV	DESCRIPTION	DATE	APPROV
1	MFG. RELEASE	10/12/93	WH
2	A CHANGES TO IMPROVE FUNCTIONALITY	3/7/96	WH
3	DWG AND P/L REVISED AND UPDATED TO REFLECT BELL MODIFICATIONS	6/15/96	NH
4	CHANGED DESIGN AFTER FIRST FUNCTION TEST CLOSURE TO 042 6450	5/26/95	

21. SECURE -43 BELT ASSY TO TOP OF -65 (OI -85) OR -47 (OF -61), LOCATE APPROX AS SHOWN.
22. WITH -137 SLEEVE IN OPEN POSITION, LOCATE RIVET APPROX AS SHOWN, TO SERVE AS A STOP FOR -137
23. DRILL WITH -37 AT VERTICAL FULL OPEN POSITION, DRILL ADDITIONAL HOLE WITH -37 AT FULL CLOSED POSITION, ASSURING -37 CLEARS ADJACENT STRUCTURE.
24. SHIM AS REQ. USING N149D033Z1 WASHERS.
25. -91 FWD BLADEFOLD ASSY FOR COMMERCIAL VERSIONS ONLY
-82 FWD BLADEFOLD ASSY FOR CANADIAN VERSIONS ONLY
26. TOLERANCE ON DECIMAL $\pm .1$
27. LAST SECTION LETTER USED "L"
28. DRILL HO. 30 (Ø.128) HOLE THRU -37 AND AND -25 (COMPONENT OF -89 ASSY). INSERT 803073 SET PIN, AND GRIND FLUSH WITH -37.

- CHAMFER EDGE FOR BETTER WELDING.

- 13 TAP HOLE TO 1/4-20 THRU

- 13 INSTALL CL-40-SBP-3 DETENT BALL INTO HOLDING FIXTURE SO THAT THE BALL IS POSITIONED SLIGHTLY ABOVE FLUSH WITH THE TUBE SEAT SURFACE. ALIGN THE TUBE IN THE FIXTURE AND MARK THE BALL CONTACT LOCATION ON THE TUBE. USE A SMALL PUNCH TO DIMPLE THE TUBE AT THE MARKED LOCATION. INSERT THE TUBE BACK INTO THE FIXTURE AND ADJUST FOR PROPER STOWING.

15. PERMISSIBLE TO SUBSTITUTE EQUIVALENT AN960 WASHER FOR NAS1149 WASHER UNTIL CURRENT STOCK IS DEPLETED.

16. PAINT ALL ASSEMBLIES AND WELDMENTS AS REQUIRED,
EXCEPT WHERE NOTED, 23663U W OHSA YELLOW, PER FED-STD-525.

- NO PAINT REQUIRED, CHEM FILM ONLY WHERE APPLICABLE.
PER PREMIER SPEC 008-93003

- 18 STITCH APPROX AS SHOWN, PER FED-STD-751.

- 19 PERMISSIBLE TO THIN NYLON WASHERS OR SUBSTITUTE WITH THINNER MS1859 EQUIVALENT.

- 26 DISENGAGE -53 HANDLE ASSY (BOTH SIDES) PRIOR TO INSTALLATION AND REMOVAL OF -01 OR -02 BLADEFOLD ASSY TO AIRCRAFT.

REFERENCE ONLY

Mo 41291

SEE SEPARATE PARTS LIST B67-4300IPL

70671-01	SINGLE-DIRECTIONAL SPECIFICATION BIMETAL SHEET AND FINISHED TOLERANCES	DRAWN BY: <i>Rick Reynolds</i>	DATE: 08/19/75	PREMIER AVIATION, INC. 200 Aviation Parkway, Grand Prairie, Texas 75050	
	DIGITALS ANGLES	CHECKED BY: RICK REYNOLDS	DATE: 08/19/75	TITLE:	
	X = .003 Y = .010	APPROVED BY: WALT HAMAKER	DATE: 08/19/75		BLADE FOLD KIT
7-06-01	USED REPLACEMENT	RELEASED BY:	DATE:		
		ATTACH DRAWN BY: ProfENGINEER	DATE:	REV. 01/03/88 B67-43001	REV. E

ORIGINAL

Date: Thursday, 25/09/2008 10:50:57 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSEMBLY

Job Number: 41291

Part Number: PB674300103

Job Number:



Seq. #:

Machine Or Operation:

Description :

48.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per dwg and use 242 threadlock A/R shown on dwg PB67-43001 page 2.

242 THREADLOCK batch: m109687

SAD

FD/M-1

08/10/29

(2)

49.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

502/10/29

(+2)

50.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PPD 41184 PPD 41183

PPD/30 (2)

51.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/30

Job Completion



~~47.1~~ - Add PB6743001-305 ^{to max} B 42995 x1, B 40063 x1, B 42655 x1, MF 08-10-29

47.2 - Add D3449-1 B 41617 x2: MF 08-10-29

MF 08-10-30

Date: Thursday, 25/09/2008 10:50:57 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSEMBLY

Job Number: 41291

Part Number: PB674300103

Job Number:



Seq. #:

Machine Or Operation:

Description :

41.0

CR3213405

cherry rivet



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
cherry rivet
batch: m104214

mf 08-10-29

42.0

MS17984C413

PIN, QUICK RELEASE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
PIN, QUICK RELEASE
batch: m18119 x 3, m108986 x 1

mf 08-10-29

43.0

MS17984C418

PIN, QUICK RELEASE



Comment: Qty.: 3.0000 Each(s)/Unit Total: 12.0000 Each(s)
PIN, QUICK RELEASE
batch: m108986

mf 08-10-29

44.0

30345T21

LANYARD



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
LANYARD
batch: m107827

mf 08-10-29

45.0

30345T24

LANYARDS



Comment: Qty.: 3.0000 Each(s)/Unit Total: 12.0000 Each(s)
LANYARDS
batch: m108390 x 9, m108913 x 3

mf 08-10-29

46.0

240107

SPRING SLOTTED PIN



Comment: Qty.: 9.0000 Each(s)/Unit Total: 36.0000 Each(s)
SPRING SLOTTED PIN
batch: m102940 x 30, m17850 x 6

mf 08-10-29

47.0

3408A98

DETENT BALL SPRING PLUNG



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
DETENT BALL SPRING PLUNG
batch: m102912 x 3, m17828 x 1

mf 08-10-29

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSEMBLY

Job Number: 41291

Part Number: PB674300103

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

AN410A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolt

batch: m105442 x 5, m101291 x 1, m107178 x 2.

MF 08-10-29

35.0

AN413A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

batch: m109282

MF 08-10-29

36.0

AN416A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Bolt

batch: m19278

MF 08-10-29

37.0

AN611A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

BOLT

batch: m105558

MF 08-10-29

38.0

AN620A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolt

batch: m104547

MF 08-10-29

39.0

AN813A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

BOLT

batch: m108986 x 2, m18180 x 6

MF 08-10-29

40.0

BSP43

RIVET



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

RIVET

batch: m109119

MF 08-10-29

Date: Thursday, 25/09/2008 10:50:57 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSEMBLY

Job Number: 41291

Part Number: PB674300103

Job Number:



Seq. #:	Machine Or Operation:	Description :
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27.0	MS518598	WASHER
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

WASHER

batch: m108986

MF 08-10-29

28.0	NAS43DD368	SPACER
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

SPACER

batch: m109060

MF 08-10-29

29.0	NAS1149F0316P	WASHER
------	---------------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

WASHER

batch: m108473

X

MF 08-10-29

30.0	NAS1149F0432P	Washer
------	---------------	--------



Comment: Qty.: 16.0000 Each(s)/Unit Total : 64.0000 Each(s)

Washer

batch: m18057

MF 08-10-29

31.0	NAS1149F0632P	WASHER
------	---------------	--------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

WASHER

batch: m18057

MF 08-10-29

32.0	NAS1149F0832P	WASHER
------	---------------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

WASHER

batch: m18057

MF 08-10-29

33.0	AN960JD6	Washer
------	----------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch: 6085

MF 08-10-29

Date: Thursday, 25/09/2008 10:50:56 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSEMBLY

Job Number: 41291

Part Number: PB674300103

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

D34479

Swing Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Swing Arm

batch: B41352

MF 08-10-29

21.0

086004

Inventory



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Inventory

batch: M17850

MF 08-10-29

22.0

MS27039107

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

batch: M108057

MF 08-10-29

23.0

MS27039123

SCREW



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

SCREW

batch: M18057

MF 08-10-29

24.0

MS21042L4

Nut



Comment: Qty.: 13.0000 Each(s)/Unit Total : 52.0000 Each(s)

Nut

batch: M104683x10, M107499x19, M108552x15, M105054x8

MF 08-10-29

25.0

MS21042L6

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Nut

batch: M108183x5, M105077x11

MF 08-10-29

26.0

MS518596

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

WASHER

batch: M17890x4, M108986x20, M108473x8

MF 08-10-29

Date: Thursday, 25/09/2008 10:50:56 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSEMBLY

Job Number: 41291

Part Number: PB674300103

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PB6743001265

Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Bushing

batch: B41373

MF 08-09-25

14.0

PB6743001299

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bushing

batch: B40062

MF 08-09-25

15.0

D3451045

Handle and Lock-Down Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Handle and Lock-Down Assembly

batch: B41065 x 2mx

MF 08-09-25

16.0

D3451047

Handle and Lock-Down Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Handle and Lock-Down Assembly

batch: B41064 x 2mx

MF - 08-09-25

17.0

D34401

Tube Guide (Supersedes B67-43001-25/-307)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Tube Guide

batch: B41347

MF 08-09-25

18.0

D34403

Clamp (Supersedes B67-43001-309)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Clamp

batch: B41277

MF 08-10-29

19.0

D34441

Velcro Loop Belt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Velcro Loop Belt

batch: B39965

MF 08-10-29

Date: Thursday, 25/09/2008 10:50:56 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSEMBLY

Job Number: 41291

Part Number: PB674300103

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PB674300137

PB67-43001-37



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

PB67-43001-37

batch: 41379

MF 08-10-21

7.0

PB674300157

Stabilizer Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Stabilizer Arm

batch: 84014

MF 08-10-24

8.0

PB674300159

PB67-43001-59



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

PB67-43001-59

batch: 41383

Sama

MF 08-10-24

9.0

PB674300163

Handle Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Handle Assembly

batch: 41384

MF 08-10-24

10.0

PB6743001135

Male Eye



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Male Eye

batch: B 239954

MF 08-09-25

11.0

PB6743001155

Pin



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pin

batch: B 41906 x 4

MF 08-09-25

12.0

PB6743001261

Lever Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Lever Arm

batch: B 41294

MF 08-09-25

Date: Thursday, 25/09/2008 10:50:56 AM
 User: Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : AFT BLADE FOLD ASSEMBLY
 Job Number : 41291 - 1
 Estimate Number : 13532
 P.O. Number : Part Number : PB674300103
 This Issue : 25/09/2008 S.O. No. : Drawing Number : B6743001 P.1,3,4,15
 Prsht Rev. : NC Project Number : N/A
 First Issue : 18/08/2008 Type : SMALL /MED FAB Drawing Revision : B1
 Previous Run : 41239 Material :
 Written By : Due Date : 15/09/2008 Qty: *split 2* Um: Each
 Checked & Approved By : *mf 08-09-25*
 Comment : Est Rev:A 08-07-30 new issue DD verified by:ec

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

PB674300109

Aft Blade Fold Assembly Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Aft Blade Fold Assembly Weldment

batch: *41200 42154**mf 08-10-30*

2.0

PB674300113

Aft Adjustable Blade Support Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Aft Adjustable Blade Support Assembly

batch: *40607 x 2**mf 08-10-24*

3.0

PB674300117

Aft Adjustable Blade Support Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Aft Adjustable Blade Support Assembly

batch: *40609 x 2**mf 08-10-24*

4.0

PB674300121

PB67-43001-21



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

PB67-43001-21

batch: *41310**mf 08-10-24*

5.0

PB674300123

PB67-43001-23



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

PB67-43001-23

batch: *41371 342972-1**mf 08-10-24*